

Work Order ID 62063-2

Wednesday, September 15, 2010 2:52:05 PM



Page 1

Item ID: D3572-041

Revision ID:

Item Name: Guide Assembly

Start Date: 9/15/2010 Start Qty: 4.00

Required Date: 9/22/2010 Req'd Qty: 4.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date: 10-9-15

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3572

Rev D

100



Pick Kit

0.00

Packaging

Memo

0.00

Packaging

m.f w/oa/2a

40

110



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

1-Cut Tube D3572-1 as per Dwg D3572
2-deburr both ends

m.f 10/09/2a

4x

120



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo A1272

0.00

Quality Control

JH-03

4

100530

Work Order ID 62063

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Page 2

Item ID: D3572-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Guide Assembly

Start Date: 9/15/2010 Start Qty: 4.00



Cust Item ID:

Required Date: 9/22/2010 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

130



Large Fab

Large Fab

Weld per dwg A/R Aluminum rod Batch: *M114703*

Memo

0.00

1-Weld D3572-3 guides and D3572-5 bracket as per Dwg D3572
2- grind weld flush at the end of tube only

R 10-11-23

(X1)

[Signature]

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

S 10/11/23

(+)

150



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

d p BE 10/11/23

Work Order ID 62063

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Page 3

Item ID: D3572-041

Accept

Revision ID:

Item Name: Guide Assembly

Start Date: 9/15/2010 Start Qty: 4.00

Required Date: 9/22/2010 Req'd Qty: 4.00

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

Chemical Conversion Coat per QSI005 4.1

0.00

HandFinish

Memo

0.00

Hand Finishing

190

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME: 8:00pm
OVEN TEMPERATURE: 320°F
FINISH TIME: 8:30pm

200

QC3- Inspect Part Finish

0.00

QC

Memo

0.00

Quality Control

1 10-11-23

1 8

10/1/24

Work Order ID 62063

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Page 4

Item ID: D3572-041

Revision ID:

Item Name: Guide Assembly

Start Date: 9/15/2010 Start Qty: 4.00

Required Date: 9/22/2010 Req'd Qty: 4.00

Reference:

Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

210



Packaging

Packaging

Identify as per dwg & Stock Location 260

0.00

Memo

0.00

10/11/24 JF 10

220



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/11/24 JF
MF
10-11-24

Picklist Print

Wednesday, September 15, 2010 2:52:09 PM

Page 1

Work Order ID: 62063

Parent Item: D3572-041

Parent Item Name: Guide Assembly

Start Date: 9/15/2010

Required Date: 9/22/2010

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A New Issue 07-02-07 JLM
 IPP rev B revB dwg EC
 IPP Rev:C Removed D3572-7 Cap 07-06-11 JLM
 IPP Rev:D 08-05-27 Review process of IPP DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M6061T6T1.000W.188

Purchased

No

110

f

63.5653

2.34

9.852632



6061T6 RD TUBE 1.00 X .188W

Loc Qty

Loc Code

1.2163

1.2163

62.349

15.516

46.833

130

Each

20.0000

4

16

9-852632

Cpl 10-10-15

D3572-3



Guide

PARTS NOT,

~~PULLED~~
 B62215 + 1

EL 10-11-23

Loc Qty

Loc Code

20

20

130

Each

25.0000

1

4

15

Cpl 10-10-15

D3572-5



Bracket

Location

Loc Qty

Loc Code

ST072

20

59405

20

WA

5

54119

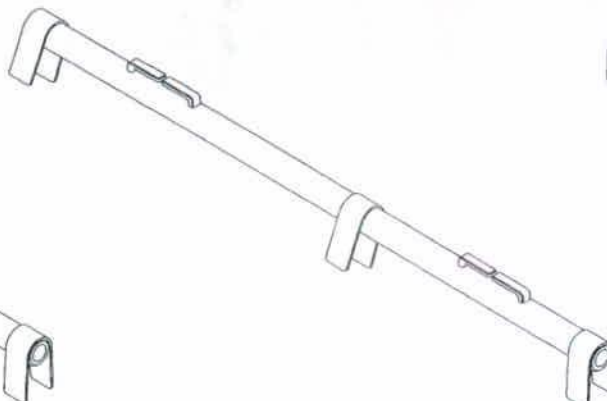
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4

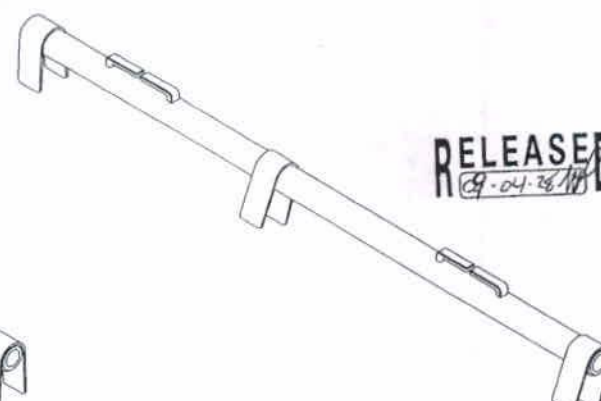
ITEM No.	QTY -041	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X			D3572-041	GUIDE ASSEMBLY
2		X		D3572-043	GUIDE ASSEMBLY (UH-1)
3			X	D3572-044	GUIDE ASSEMBLY (UH-1) (OPP)
11	1	1	1	D3572-1	TUBE
12	4	4	4	D3572-3	GUIDE
13	1	3	3	D3572-5	BRACKET
14	-	-	-	D3572-7	DELETED AT REV C



D3572-041 GUIDE ASSEMBLY



D3572-043 GUIDE ASSEMBLY (UH-1)



D3572-044 GUIDE ASSEMBLY (UH-1)

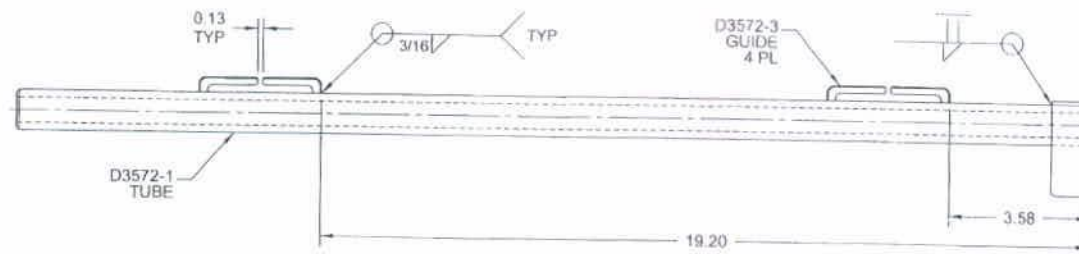
NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANOTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3572-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.34 lbs
-043/-044: 1.42 lbs
- 8) WELDING: PER DART QSI 004

D	REDRAWN IN "B" SIZE FORMAT TO CURRENT STANDARDS. ADD -043, -044 FOR UH-1. SEE PAR 09-017	AJS	09.04.17
C	REMOVE D3572-7	LE	07.06.01
B	FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET	LE	07.04.20
A	NEW ISSUE	LE	07.03.29
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. D
MFG. APPR.		D3572	SHEET 1 OF 4
APPROVED		TITLE	SCALE
DE APPR.		GUIDE ASSEMBLY	NTS
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09-04-26-11

UNP
CROSS
W
NO 42063
B/10-9-15

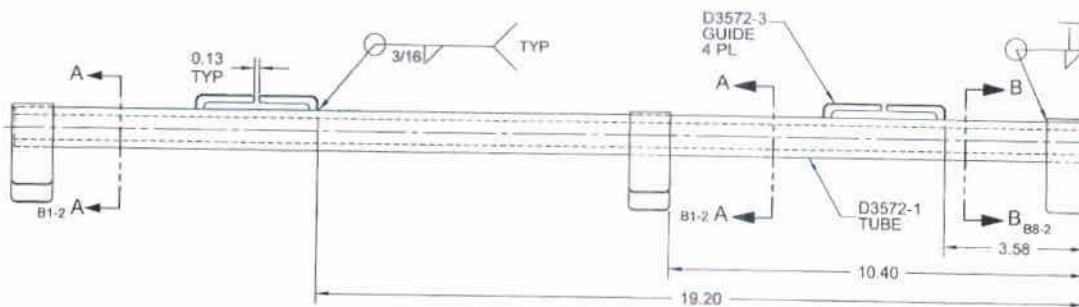


D3572-041 GUIDE ASSEMBLY

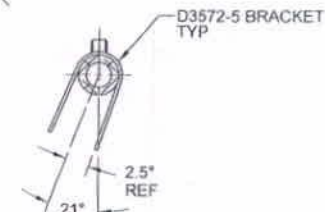


D3572-5 BRACKET

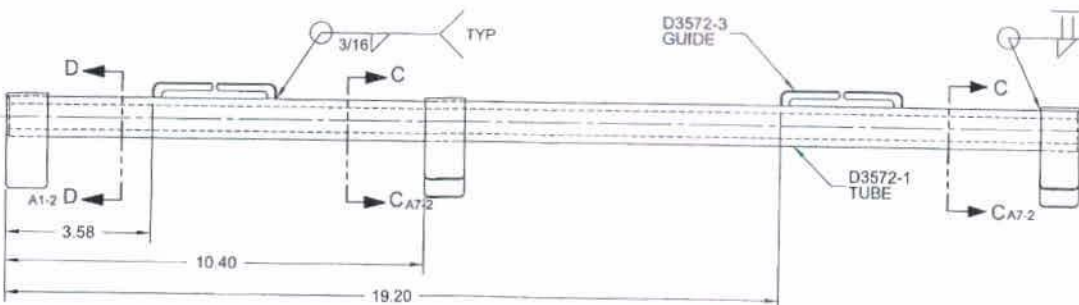
w/662063



D3572-043 GUIDE ASSEMBLY



SECTION A-A
(2 PL) C7-2 C4-2



D3572-044 GUIDE ASSEMBLY



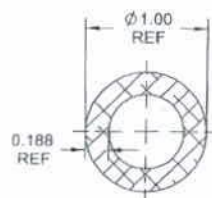
SECTION D-D A7-2

SECTION B-B C2-2

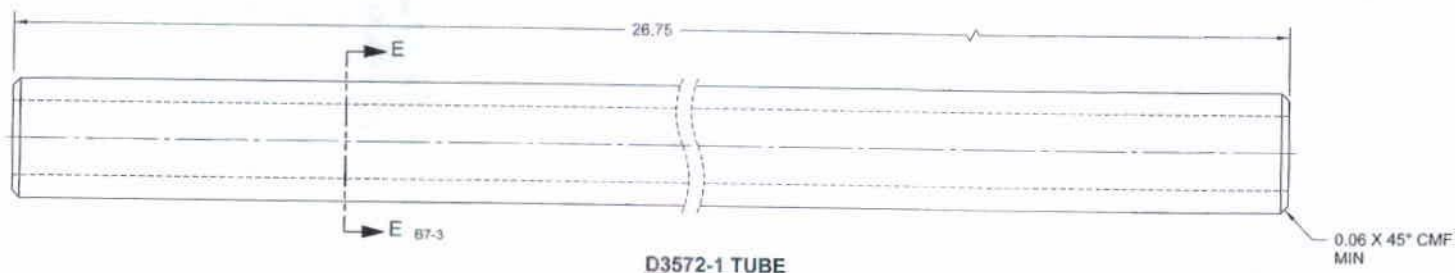
SECTION C-C A2-2 A5-2

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SECTION E-E C5-3



D3572-1 TUBE

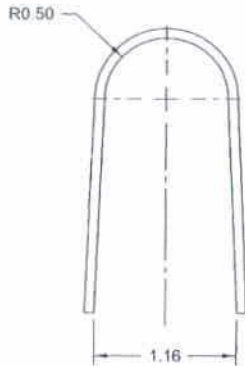
w/o 62063

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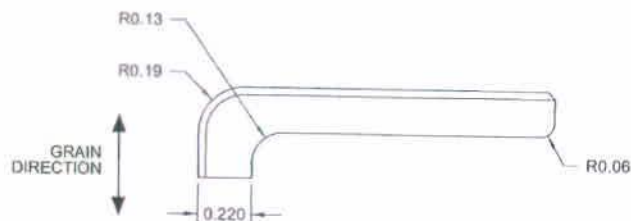
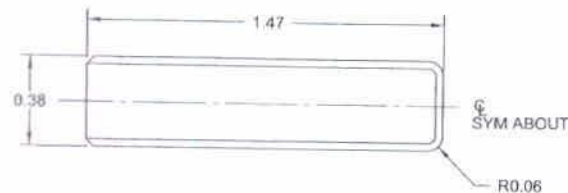
D3572-1 NOTES:

- 1) MATERIAL: 6061-T6 (T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR AMS-QQ-A-200/8 OR AMS-QQ-A-225/8
REF DART SPEC M6061T61.000W.188
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.25 lbs

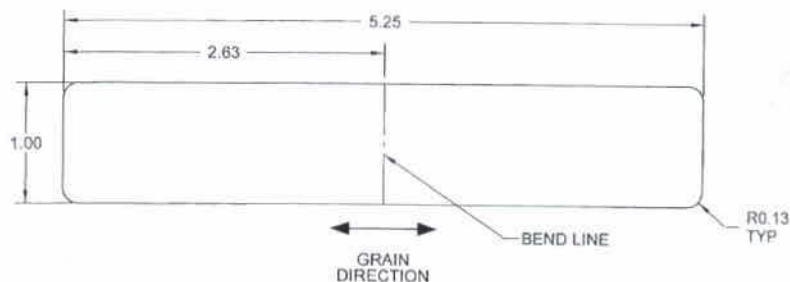
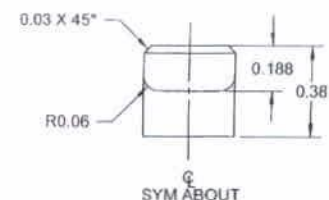
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DRAWN	AJS		
CHECKED	h	DRAWING NO. D3572	REV. D
MFG. APPR.	CF	SHEET 3 OF 4	
APPROVED	h	TITLE	SCALE
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D3572-5 BRACKET
(MAKE FROM D3572-5F)



D3572-3 GUIDE



D3572-5F FLAT PATTERN

w/o block 3

RELEASED
09/04/17

D3572-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M6061T6B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

D3572-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M60601T6S.080
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

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MFG APPR.		D3572	SHEET 4 OF 4
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